



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3712-041
Job Sheet 178097



Part No: D3712-041

Job Qty: 1 ea

Part Name: Basket Base Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/26/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3726 REV A, D3727 REV A, D3739, D3740 REV A, D3712 REV B, D3735 REV B, D3746 REV B IPP
Rev:A new issue 08-01-30 DD verified by:EC IPP Rev:B chg to revB ecn1145 08-03-19 DD verified by:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/15/18	0.00	0.00	Start Up Large Fab-5		D.M.L 18-6-11
100	Large Fab	1 pcs		6/15/18	0.00	16.67	Large Fab 8		D.M.L 18-6-11
110	Large Fab	1 pcs		6/15/18	0.00	16.67	Large Fab 1		C 18-6-11
120	QC	1 pcs		6/15/18	0.00	0.00	QC5		D 18-06-14
130	QC	1 pcs		6/15/18	0.00	0.00	QC9		D 18-06-14
135	HandFinish	1 pcs		6/15/18	0.00	0.57	HandFinish2		REF 18-06-19
140	Powdercoat	1 pcs		6/15/18	0.00	1.28	Powdercoat2		DL 18-6-19
150	QC	1 pcs		6/15/18	0.00	0.00	QC3		HL 18-6-19
160	Packaging	1 pcs		6/15/18	0.00	0.00	Packaging1-4		HL 18-6-19
170	Small Fab	1 pcs		6/15/18	0.00	0.54	Small Fab-4		HL 18-6-19
180	QC	1 pcs		6/15/18	0.00	0.00	QC5		HL 18-6-19
190	Packaging	1 pcs		6/15/18	0.00	0.00	Packaging3-1		HL 18-6-20
200	QC21-SA	1 Ea		6/15/18	0.00	0.00	QC21		HL 18-06-20

Part Op 100 - 1- take D3166-1 and trim as per dwg D3746 to make D3746-1, D3746-3, D3746-5 and D3746-7

Descriptions: 110 - 1- cut mesh to fit inside basket base and sides as per dwg D3744 and D3745

140 - START TIME

170 - Assemble as per dwg D3712

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2327-3	Spacer Bushing	2 Ea (2 ea)	90-Start up Operation	5079118
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5061216
D3166-1	Basket Hoop	5 Ea (5 ea)	90-Start up Operation	5057886
D3725-1	Hoop	2 Ea (2 ea)	90-Start up Operation	5058070
D3748-1	Hinge Half	3 Ea (3 ea)	90-Start up Operation	5075745
M304TS0.750W.065	304 Sq Tube .75X.75X.065W	42.6590 ft (42.659 ea)	90-Start up Operation	5059803
MS21042L3	Nut	6 Ea (6 ea)	90-Start up Operation	5062372
D3759-1	Bushing	21 Ea (21 ea)	110-Large Fab	5057548
AN3-11A	Bolt	6 Ea (6 ea)	170-Small Fab	5027721
D2931	Bumper	2 Ea (2 ea)	170-Small Fab	506435
D3757-1	Blanking Plate	2 Ea (2 ea)	170-Small Fab	5045415
M304EX0.75-16F	Expanded Metal Flat SS	38 sf (38 ea)	170-Small Fab	5070544
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	170-Small Fab	5042091

M.U. 003803

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

NAS1149D0363J
NAS1149DN832J

Washer
Washer

12 Ea (12 ea)
2 Ea (2 ea)

170-Small Fab
170-Small Fab

501526
503411

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2327-3	2	0	0
	D2581	2	73	0
	D3166-1	5	30	0
	D3725-1	2	6	0
	D3748-1	3	1	0
	M304TS0.750W.065	43	1,059	0
110-Large Fab	MS21042L3	6	1,322	0
	D3759-1	21	134	0
170-Small Fab	AN3-11A	6	125	0
	D2931	2	1,038	0
	D3757-1	2	6	0
	M304EX0.75-16F	38	1,570	0
	MS20600-AD4W3	2	203	0
	NAS1149D0363J	12	2,848	0
	NAS1149DN832J	2	1,864	0

Part Specifications

Specifications could not be found.

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
DART Aerospace Ltd. 1270 Aberdeen Street Newbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaero.com DART AEROSPACE Container No: S079945 Part: D3712 - 041 Job No: 178097 Serial No/Batch: S079945 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 06/11/18	QTY Effective : _____			MRB (QSI042) Approval	
	Disposition			Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
FAULT CATEGORY					
Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ t Expiry Date ☐ Identified ☐	Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	efect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
OTHER : _____					